

Date: Wednesday, 03/09/2008 10:29:35 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 41740		
Estimate Number	: 11040		
P.O. Number	:	Part Number	: D28042
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: D2804 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29410	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JL 008.9.03</u>		
Comment	: Est. A00.11.06 New Issue EC		
	: Est. B06.05.30 Blanks on wtjetEC		
	: Est Rev:C As per Rev C 06-11-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00
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10x



Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s) $108614 \times 2 = 1.57$
 6061-T6 Bar .50" x 12.0" $6-3$
 Material: 6061-T6 bar 12.00" x 0.50" Batch: $109253 \times 8 = 89-19$

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Template DT8534
 Dwg Rev: C
 Prog Rev: C 1B 8-9-19

(10)

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA103

JL 08/10/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/10/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

(10)
 M.A 08/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:35 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 41740

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

nlh 08/10/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/14

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

yl

08-10-15

X10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/10/15

10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST151 A*

yl 08/10/16

X10

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/17

Job Completion



mf 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41740
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

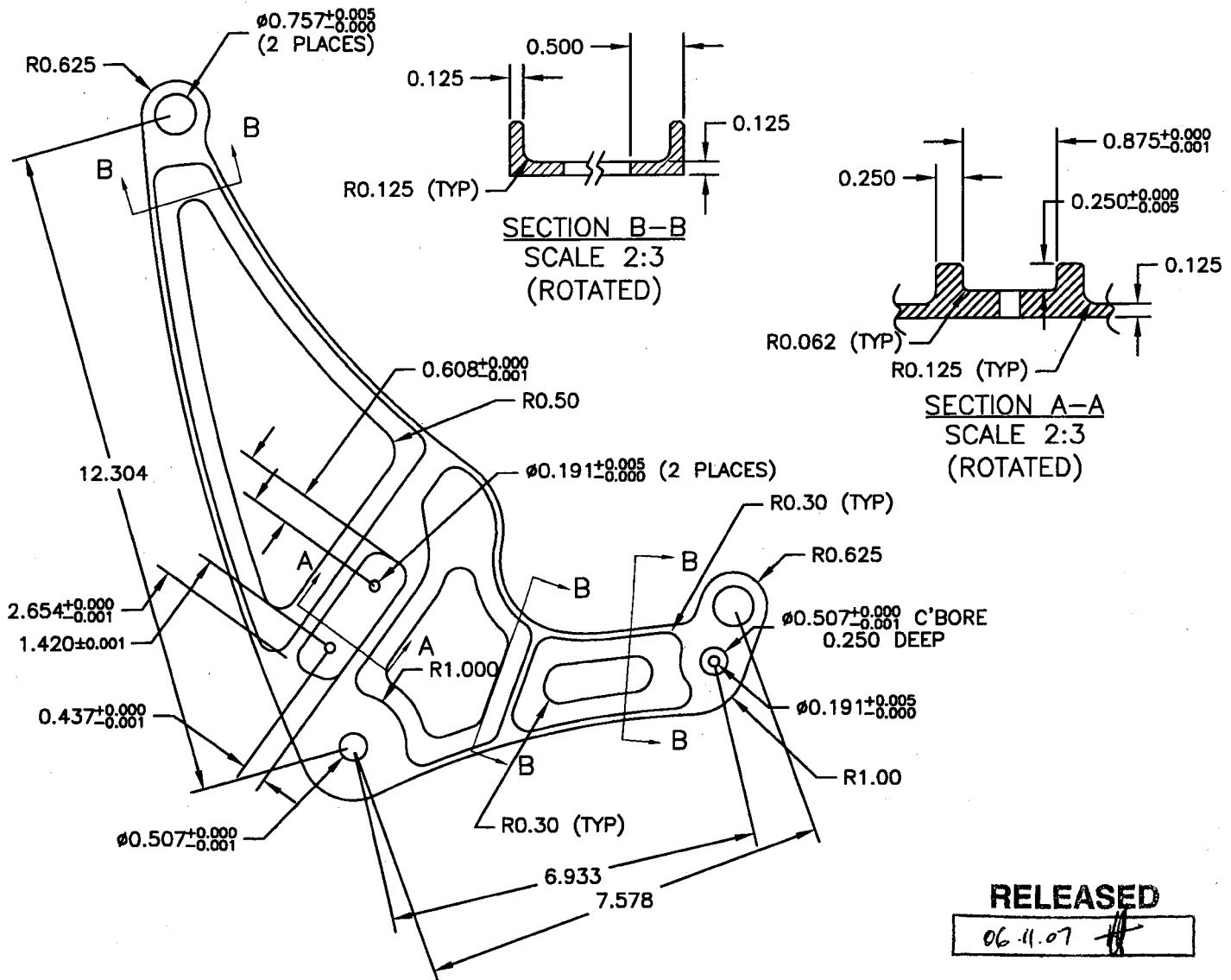
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.126	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.251	✓			
0.250	+0.000/-0.005	.246	✓			
0.875	+0.000/-0.001	.874	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.759	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.304	✓			
Ø0.507	+0.000/-0.001	.5063	✓			
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	.608	✓			
Ø0.191	+0.005/-0.000	.191	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	.247	✓			
6.933	+/-0.005	6.932	✓			
7.578	+/-0.005	7.578	✓			
0.500	+/-0.010	.500	✓			

Measured by: J.L	Audited by: M.A	Prototype Approval:	N/A
Date: 08/10/10	Date: 08/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	BE

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**RELEASED**

06.11.07 #

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

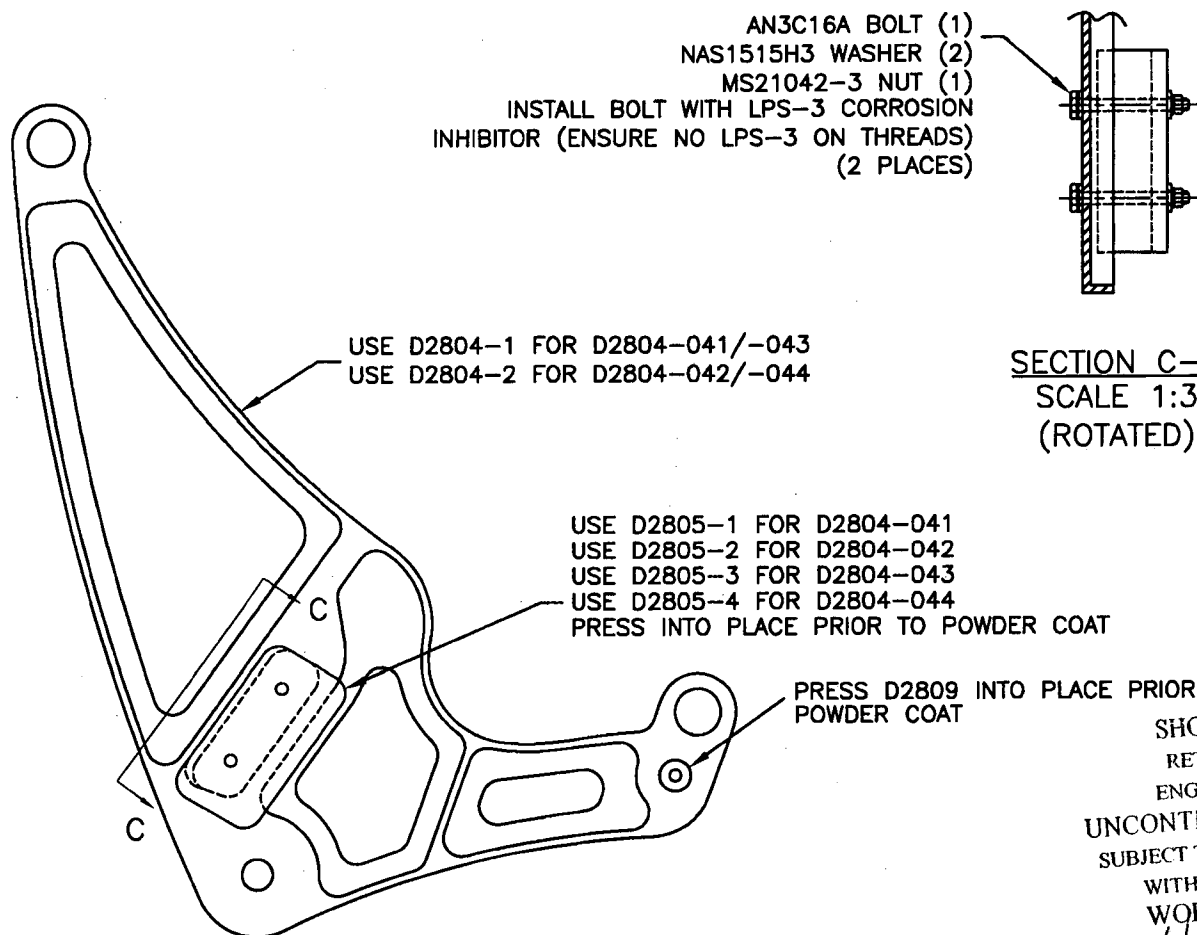
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NO 41740

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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NO. 41740

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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